

Shop 08/05

Date: Thursday, 5/10/2007 2:23:41 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE	
Job Number	32269		Part Number	D353525	
Estimate Number	12734		Drawing Number	D3535 UNDER REVIEW	
P.O. Number	N/A		Project Number	N/A	
This Issue	5/10/2007	S.O. No.	AB P# 07-05-10		
Prsht Rev.	NC		Drawing Revision		
First Issue	N/A		Material	N/A	
Previous Run	N/A		Due Date	5/17/2007	
Written By			Qty:	4 Um: Each	
Checked & Approved By	07-05-10				
Comment	Est Rev: A New Issue 07-02-15 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M304S20GA	304/316 .040 Sheet		
		Comment: Qty.: 0.5355 sf(s)/Unit Total : 2.1420 sf(s) 304/316 .040 Sheet (M304S20GA)		
		Batch: M101 873 (3) M103713 (1) SAD 07/05/14		
2.0	WATER JET	FLOW WATER JET		
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: 13 Prog Rev: 13	NOTE: CHECK Rev of Dwg and Flat pattern	
		2-Deburr if necessary	SAD 07/05/14	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/05/14	
4.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK	20705-15 (4)	
5.0	BRAKE NC	NC BRAKE		
		Comment: NC BRAKE 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25	MF 07-05-16 MF 07-05-16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

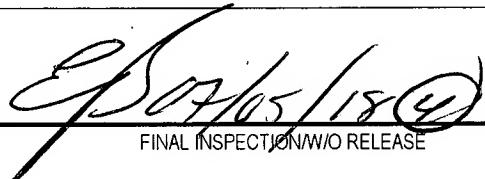
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:23:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARSHOE
Job Number: 32269		Part Number: D353525
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		SB 07/08/16 (4)
7.0	POWDER COATING	POWDER COATING  M101601
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		UJ 07-05-17 (4)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		EBS/07/05/18(4)
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ 		
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		DAK/05/18 (4)
Job Completion  		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

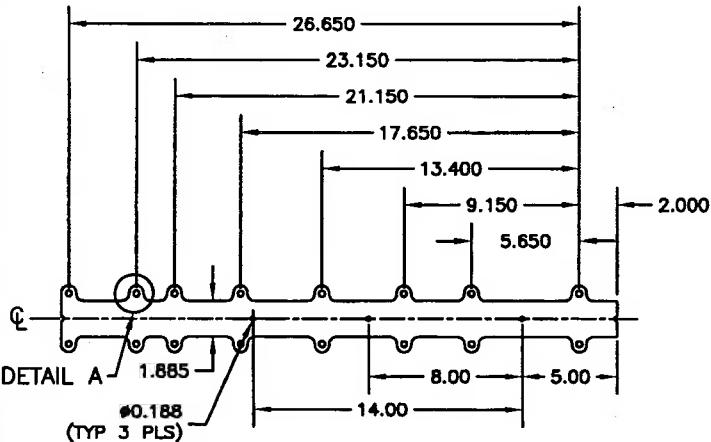
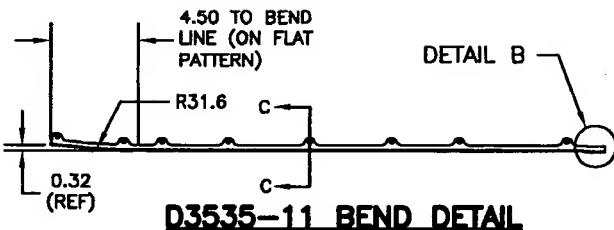
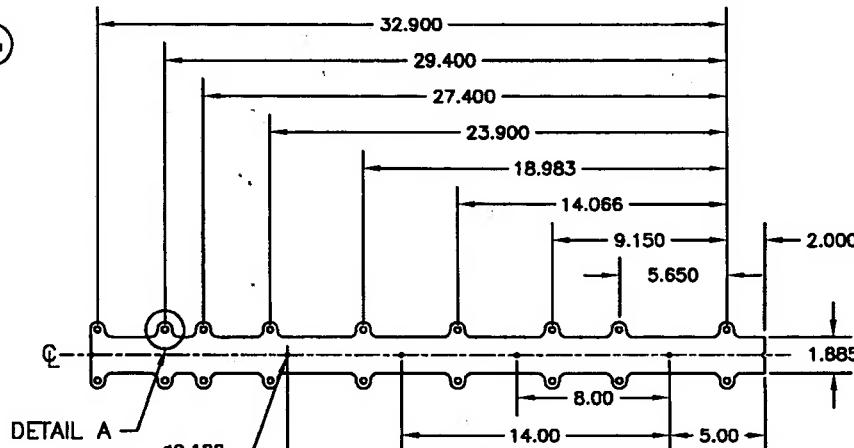
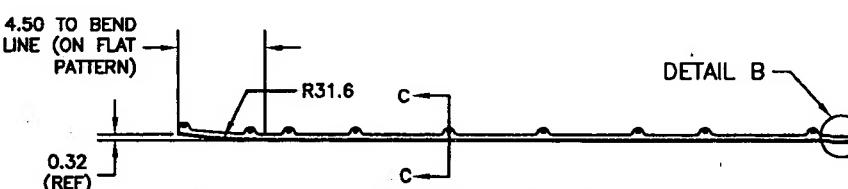
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/14	Z-0	wrong Re Scrap one part wrong Revision	QSI042	Scrap - destroy replace	SAM 07/05/14	QAO5-15	QSI042	QAO5-15

NOTE: Date & initial all entries

DARTRELEASED
57.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	P#	PRT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
TW	TW	D3535
DATE		TITLE
07.04.17		WEARSHOE
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB. OUTBOARD, ADD AMS SPEC

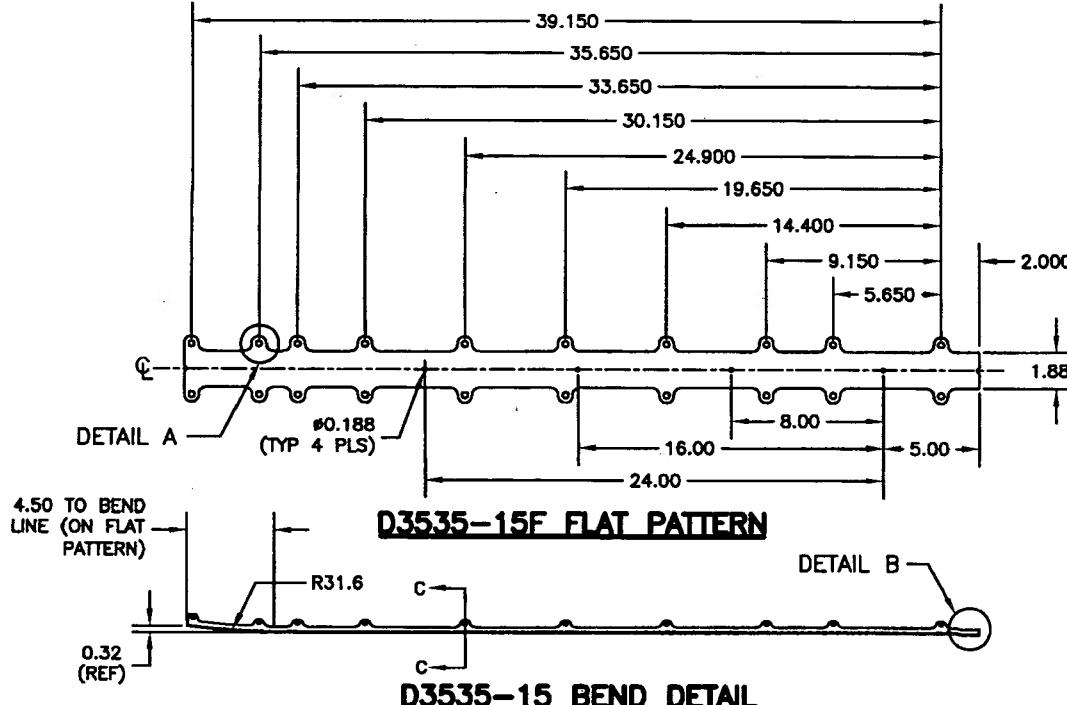
**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****Copyright © 2006 by DART AEROSPACE USA, INC.**

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WORK ORDER

NOTES

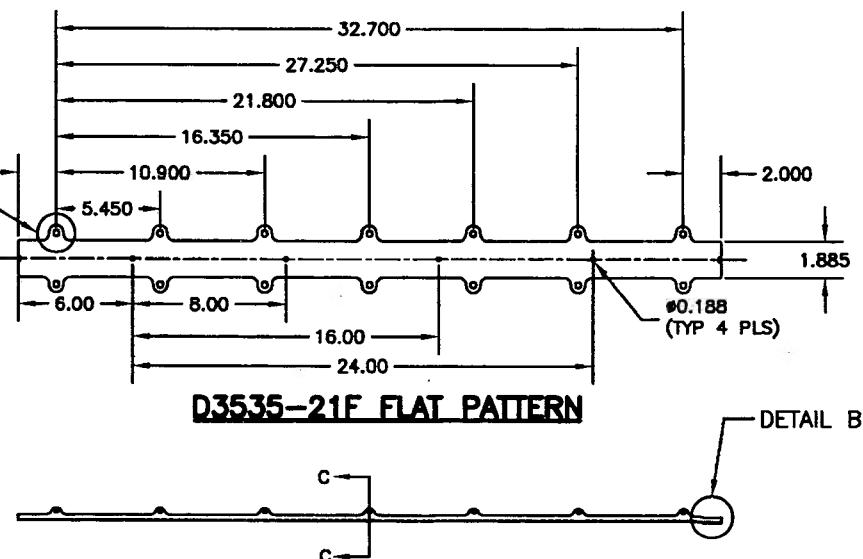
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20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
- PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- SEE PAGE 7 FOR DETAILS AND SECTION



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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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CHECKED <u>MH</u>	APPROVED <u>MH</u>	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE
		REV. B SHEET 2 OF 7 SCALE 1:10

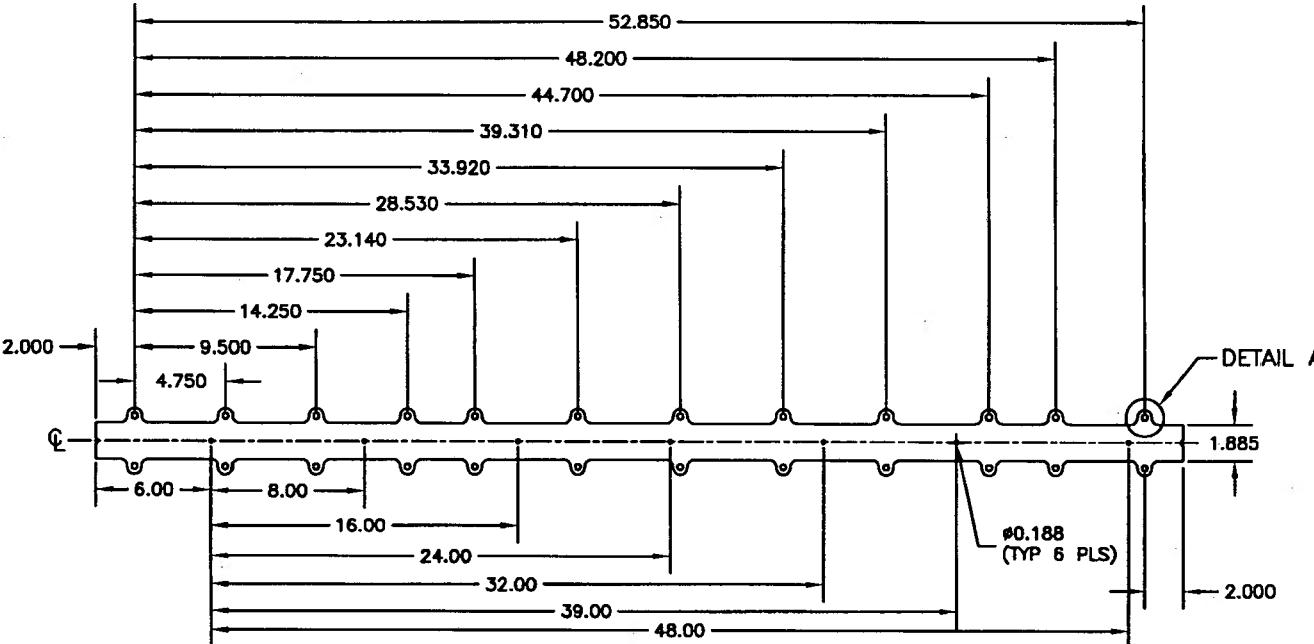
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07.04.24

DART

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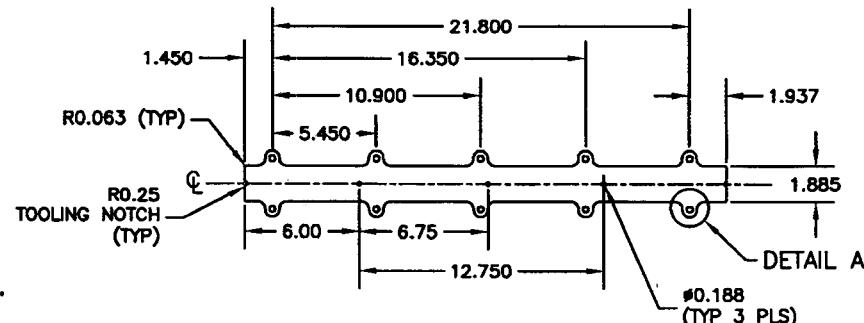
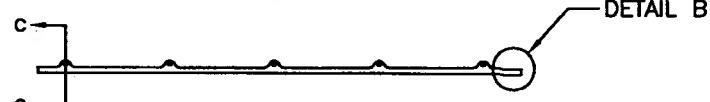
07.04.24

**D3535-23F FLAT PATTERN**

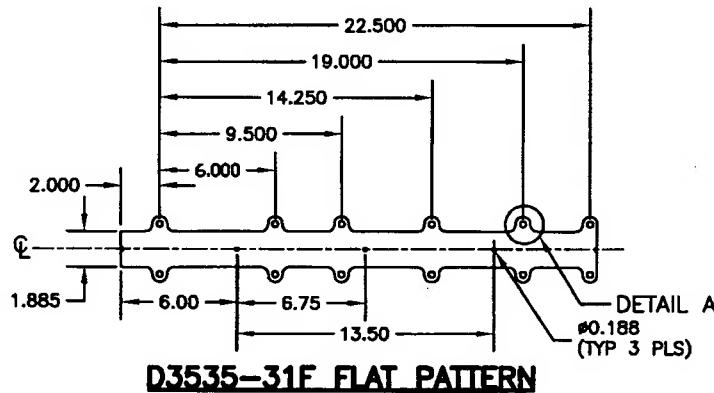
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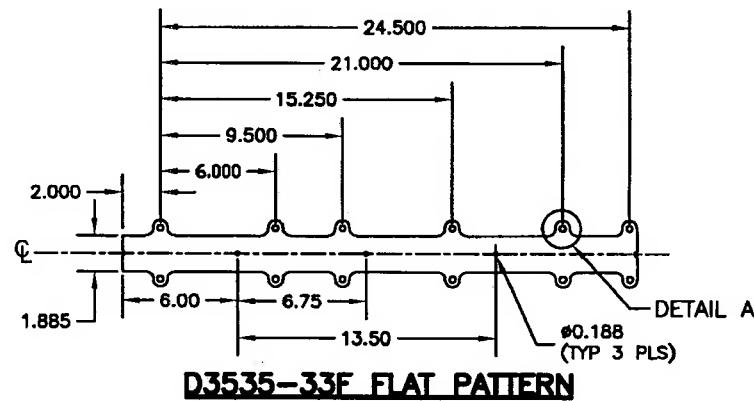
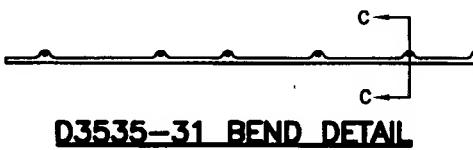
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
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**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL**

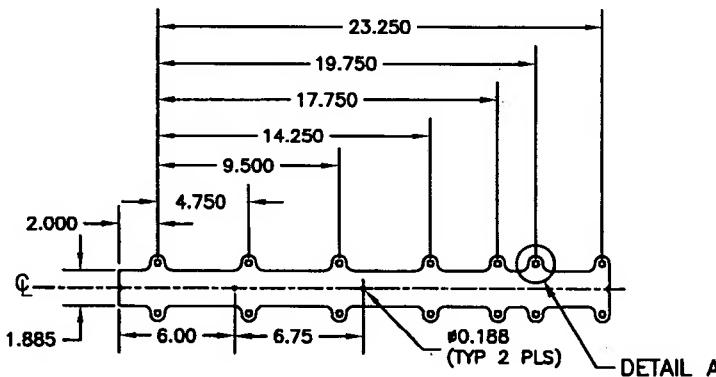
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C.B	PW	PORT HADLOCK, WA
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		D.3535
DATE		TITLE
07.04.17		WEARSHOE
		REV. B
		SHEET 3 OF 7
		SCALE
		1:10



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07.04.17



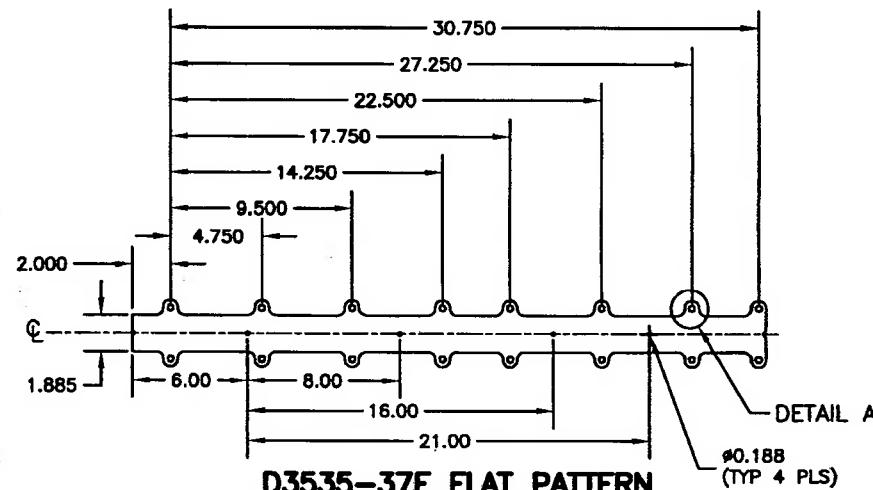
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DATE		TITLE	SCALE
CB	PH	D3535	1:10
07.04.17		WEARSHOE	

DARTRELEASED
07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

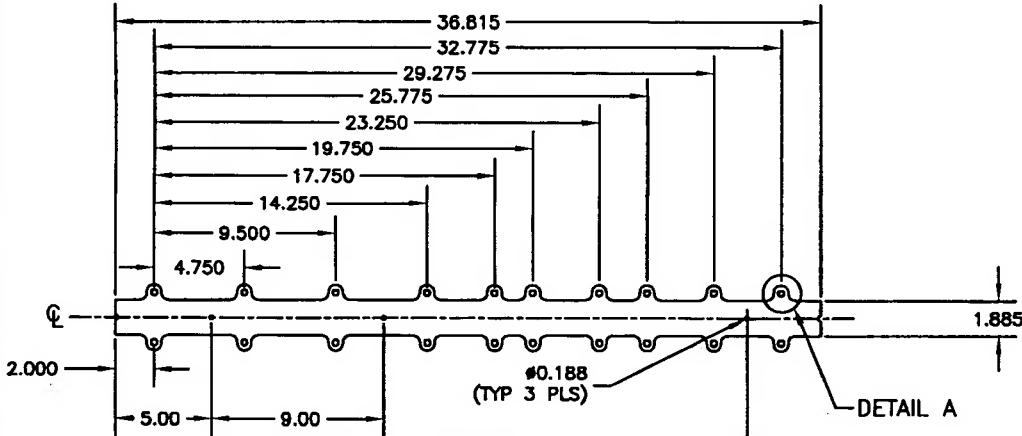
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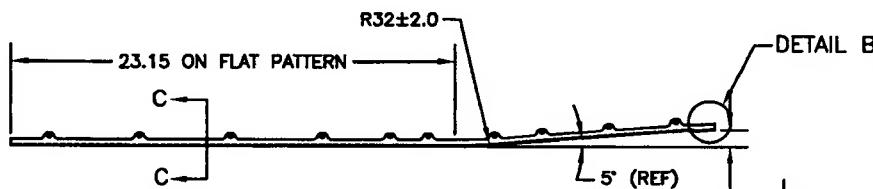
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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<i> </i>	<i> </i>	WEARSHOE	1:10
DATE		TITLE	SCALE
07.04.17			



D3535-39F FLAT PATTERN

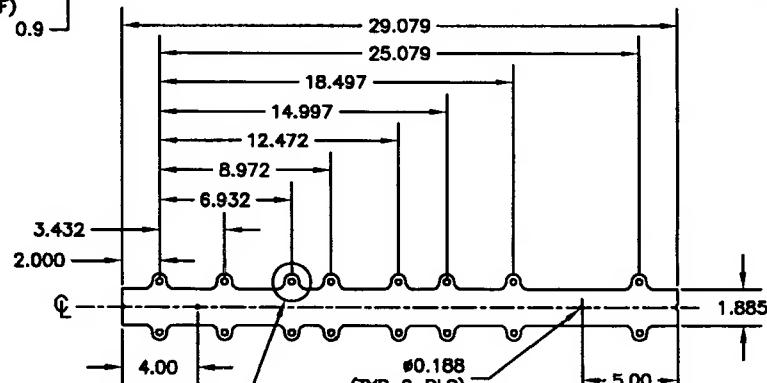


D3535-39 BEND DETAIL

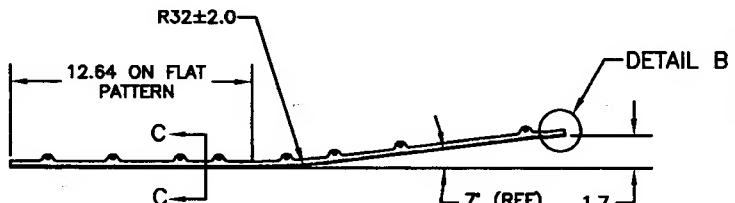
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
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D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		WEARSHOE
07.04.17		

REV. B
SHEET 6 OF 7
SCALE 1:10

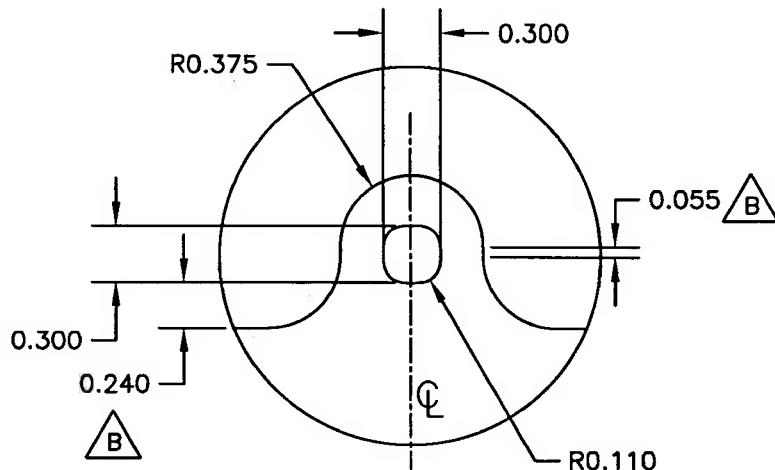
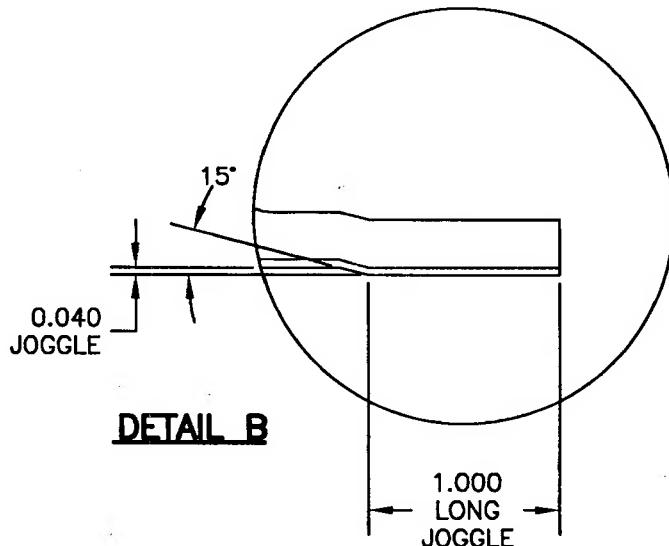
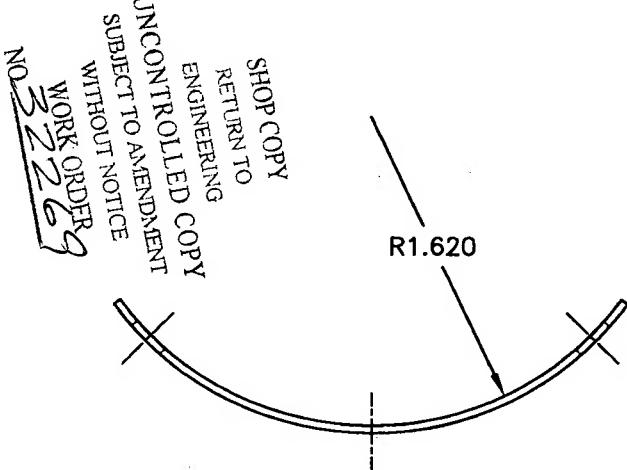
DART

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[Signature]

07.04.24

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 7 OF 7 SCALE 1:1

**DETAIL A****DETAIL B****SECTION C-C**

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DART AEROSPACE LTD

Work Order: 32269

Description: WEARSHOE

Part Number: D353525

Inspection Dwg: D3535 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 21.800	+/- 0.010	21.800	/		M-T/Vern	
B 16.350	+/- 0.010	16.350	/		M-T/Vern	
C 10.900	+/- 0.010	10.900	/		M-T/Vern	
D 5.450	+/- 0.010	5.447	/		Vern	
E 1.450	+/- 0.010	1.458	/		height-gauge	
F 6.00	+/- 0.030	6.01	/		height-gauge	
G 6.75	+/- 0.030	6.749	/		height-gauge	
H 12.750	+/- 0.010	12.750	/		M-T	
I 1.885	+/- 0.010	1.892	/		Vern	
J 1.937	+/- 0.010	1.937	/		M-T/ ^{height} gauge	
K 0.300	+/- 0.010	0.302	/		Vern	
L 0.300	+/- 0.010	0.302	/		Vern	
M 0.038	+/- 0.010	0.037	/		Vern	
N 0.188	+/- 0.005 0.001	0.191	/		Vern	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD
Date: 07/05/14

Audited by:
Date: 07/05/15

Prototype Approval: WA 3
Date: WA 07.05.

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

